

Date: Wednesday, 2/15/2006 3:46:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
 Job Number : 25832
 Estimate Number : 10533
 P.O. Number : N/A Part Number : D2573
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2573 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 25619 Material : N/A
 Due Date : 3/15/2006 Qty: 11 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06-02-16
 Comment : Est: 1 As Per RevE 06-01-27 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B24070

J.G. 06/02/26

16

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 25832 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

Ep 06/03/04 J.G. 06/02/27 11

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

Ep 06/03/04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ep 06/03/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25832

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 06-03-04 10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:03:06: (11)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

G. m 06-03-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

W

06 03 06

(11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

C20403107

(11)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/08

(11)

Job Completion



U 06-03-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25832
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.746	1.747		
C	3.495	3.505		3.497	3.497	3.498	3.498		
D	1.745	1.755		1.746	1.746	1.746	1.747		
E	7.990	8.010		8.004	8.005	8.006	8.007		
F	0.490	0.510		0.498	0.496	0.499	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.504	0.503	0.502		
J	1.174	1.184		1.177	1.178	1.177	1.178		
K	0.558	0.578		0.564	0.566	0.565	0.568		
L	1.174	1.184		1.177	1.178	1.177	1.178		
M	1.365	1.375		1.368	1.370	1.368	1.368		
N	2.495	2.505		2.497	2.496	2.498	2.495		
O	4.119	4.129		4.120	4.123	4.122	4.121		
P	0.115	0.135		0.122	0.123	0.121	0.120		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.248	0.248	0.250		
S	0.115	0.135		0.122	0.130	0.131	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.232	0.238	0.240	0.241		
W	0.115	0.135		0.130	0.131	0.131	0.132		
X	0.308	0.313		0.309	0.309	0.309	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.367	0.367	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.633	0.629	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.250	0.245		
AE	1.500	1.520		1.518	1.511	1.507	1.507		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.242	0.250	0.249	0.252		
AI	2.000	2.020		2.000	2.001	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En
Date:	06/03/01

Audited by:	J-L
Date:	06-03-04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	25832
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.748	1.749	1.747	1.747		
C	3.495	3.505		3.499	3.500	3.499	3.499		
D	1.745	1.755		1.748	1.748	1.747	1.747		
E	7.990	8.010		8.002	8.002	8.004	8.004		
F	0.490	0.510		0.500	0.501	0.501	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.498	0.499	0.499		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.567	0.568	0.569		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.370	1.371	1.372	1.371		
N	2.495	2.505		2.498	2.499	2.499	2.500		
O	4.119	4.129		4.128	4.124	4.124	4.123		
P	0.115	0.135		0.120	0.120	0.121	0.125		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.251	0.255	0.254	0.249		
S	0.115	0.135		0.127	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.221	3.221	3.221		
V	0.230	0.250		0.237	0.237	0.238	0.238		
W	0.115	0.135		0.127	0.129	0.129	0.129		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.629	0.632	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.253	0.254		
AE	1.500	1.520		1.513	1.514	1.513	1.513		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.255	0.255	0.254	0.254		
AH	0.240	0.260		0.250	0.251	0.251	0.249		
AI	2.000	2.020		2.003	2.003	2.002	2.0025		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G.
Date:	06/03/02

Audited by:	J.L.
Date:	06.03.04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	25832
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438			
B	1.745	1.755		1.747	1.745	1.746			
C	3.495	3.505		3.499	3.497	3.498			
D	1.745	1.755		1.747	1.745	1.746			
E	7.990	8.010		8.004	8.006	8.003			
F	0.490	0.510		0.501	0.497	0.502			
G	0.257	0.262	DT8683	0.257	0.257	0.257			
H	0.375	0.380	DT8684	0.375	0.375	0.375			
I	0.490	0.510		0.500	0.501	0.502			
J	1.174	1.184		1.177	1.176	1.177			
K	0.558	0.578		0.558	0.566	0.566			
L	1.174	1.184		1.177	1.176	1.177			
M	1.365	1.375		1.371	1.367	1.368			
N	2.495	2.505		2.499	2.496	2.498			
O	4.119	4.129		4.120	4.124	4.123			
P	0.115	0.135		0.127	0.124	0.124			
Q	0.115	0.135		0.130	0.130	0.130			
R	0.240	0.260		0.250	0.250	0.250			
S	0.115	0.135		0.131	0.127	0.126			
T	0.178	0.198		0.188	0.188	0.188			
U	3.210	3.250		3.221	3.230	3.230			
V	0.230	0.250		0.239	0.237	0.234			
W	0.115	0.135		0.127	0.132	0.132			
X	0.308	0.313		0.310	0.310	0.310			
Y	0.760	0.765		0.760	0.760	0.760			
Z	0.352	0.372		0.360	0.360	0.360			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.628	0.628	0.630			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.250	0.242	0.246			
AE	1.500	1.520		1.512	1.511	1.510			
AF	0.115	0.135		0.130	0.130	0.130			
AG	0.240	0.280		0.250	0.260	0.260			
AH	0.240	0.260		0.249	0.249	0.244			
AI	2.000	2.020		2.002	2.002	2.002			
AJ	0.023	0.043		0.030	0.030	0.030			
Accept/Reject									






Measured by:	J.G./ E
Date:	06/03/03 06/03/04

Audited by:	J.L
Date:	06.03.04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

00 ✓ 0.000

VIEW B-B

1.73

0.20

2

R0.66 (TYP)

R0.50 (TYP)


DART

1.750 ± 0.005

3.500 ± 0.005

1.750 ± 0.005

8.000

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2573
DATE 05.07.13	TITLE OUTER AFT SADDLE	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSES
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
QART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25832